

**Work Order ID 48240**

Friday, June 26, 2009 8:57:04 AM



Page 1

Item ID: D3040-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 7/15/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 40.00



Customer:

**Reference:****Approvals:**

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3040	Rev B

100 0.00



FLOW WATER JET

Waterjet

**Memo**

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3041  Dwg Rev: B  Prog Rev: B  2-  
Deburr if necessary

HB 9-7-2

HB 9-7-2

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

**Memo**

0.00

Quality Control

120 0.00



QC8- Inspect parts - second check

QC

**Memo**

0.00

Quality Control

⇒ 509/07/06

**Work Order ID 48240**

Page 2

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Item ID: D3040-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 7/15/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 40.00



Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

130

Identify as per dwg &amp; Stock Location



Packaging

Packaging

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

**Picklist Print**

Page 1

Friday, June 26, 2009 8:57:04 AM

Work Order ID: 48240



Parent Item: D3040-3RevB



Parent Item Name: Mounting Lug

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased		No		100	f	0.0000	14.9095			

6061-T6 Bar .178 x 4.00



M 106649

HS 9-7-2



Date: Thursday, 28/05/2009 9:11:50 AM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	48240			Part Number	: D30403		
Estimate Number	11535			Drawing Number	: D3040 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	28/05/2009	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	: 04/06/2009 Qty: 40 Um: Each		
Previous Run	42945						
Written By	:						
Checked & Approved By	<u>JUL 09 - 05 - 28</u>						
Comment	Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:C Now on Waterjet 07-03-07 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00	
Comment: Qty.: 0.3718 f(s)/Unit Total : 14.8722 f(s) 6061-T6 Bar .178" x 4.0" Material: 6061-T6 alum plate 0.188" thick Batch: <u>106649</u> <u>IB 9-7-2</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3041 Dwg Rev: <u>B</u> <u>IB 9-7-2</u> Prog Rev: <u>B</u>			
2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<u>IB 9-7-2</u>			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
<u>IB 9-7-2</u>			
Comment: SECOND CHECK			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
<u>Sc 09/07/09</u> <u>(KSC)</u>			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 48240

Part Number: D30403

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48240
Description: Mounting Lug	Part Number:	D3040-3
Inspection Dwg: D3040	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

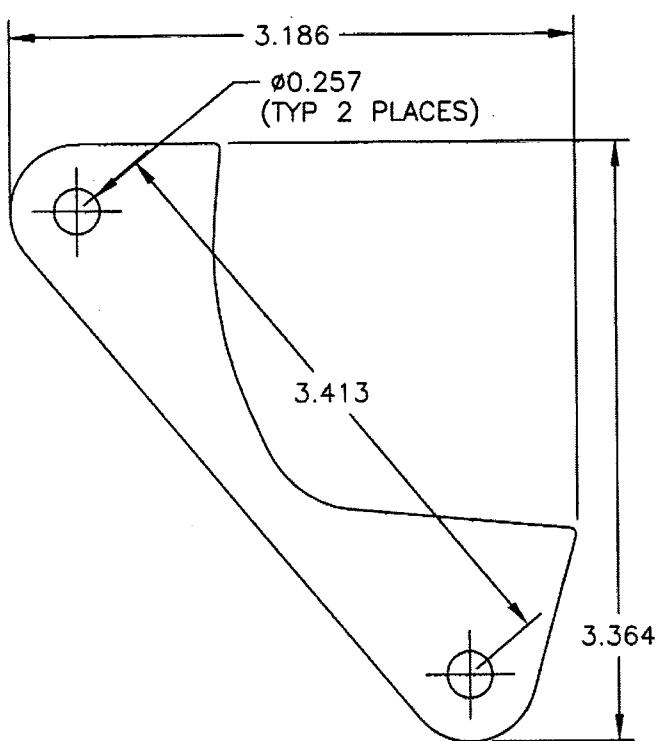
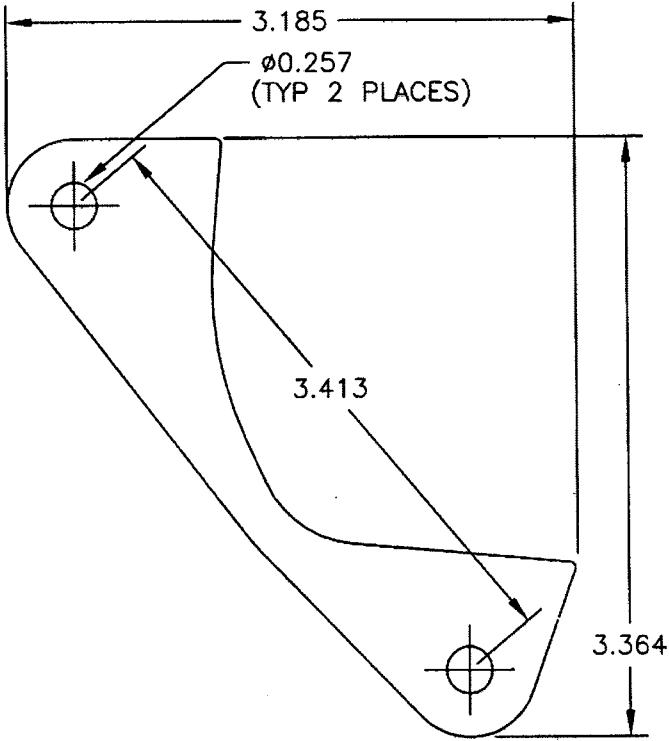
## X First Article      Prototype

Measured by:	<u>LR</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>9-7-2</u>	Date:		Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.04.20	New Issue	KJ/JLM	SJL

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3040	REV. B SHEET 1 OF 1
DATE 01.09.04		TITLE MOUNTING LUG	SCALE 1:1
A	01.06.27	NEW ISSUE	
B	01.09.04	CHANGED PROFILE 5 DEGREES	

**RELEASED**  
01.09.07D3040-1D3040-3NOTES

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK  
(REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48240

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